

Work Order ID 73681

Tuesday, September 13, 2011 10:18:56 AM

Page 1

Item ID: D206-642-541

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 9/13/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: /Date: 7-09-13

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3274

D

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

N/A JD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch: M112860

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D32748 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe
batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

MO/ 11-09-14

DL 11/09/15

BE 11/09/15

DL 11/09/15

Dart Aerospace Ltd

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
114 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8	11/02/19				
116 QC Quality Control	QC10- Inspect visual per QS1004- ground welds Memo	0.00 0.00		8	11/02/19				
120 HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00		JW	11-09-22				

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC3- Inspect Part Finish

0.00

DD

11-9-26



QC Memo

0.00

Quality Control

150 Skidtubes

0.00



Skidtubes Memo

0.00

Skidtubes 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

3 DL 11/09/26

Pho →

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☐ *110393* ☐

Sikaflex expire date: *12/04/05*

Start: *11/09/27* Time: *7:38 am*

Finish: *11/09/27* Time: *3:00*

(Adhere for 12 hours)

DL 11/09/27

Dart Aerospace Ltd

W/O: 73681

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-541 PAR #: N/A Fault Category: Landing gear / slip NCR: Yes No DQA: NA Date: 11.10.25
 Resolution: be work Disposition: be work QA: N/C Closed: ✓ Date: 11/10/25

NCR: 11-919

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/09/26	#150	when opening up .375" hole operator drill the wrong hole						
11/09/26	#150	when opening up .375" hole operator drill the 11th hole. b. .375" should be @ .313". R.C. h.c.a. hole is located next to .375" hole.	CP 11.09.26 DS/042	INSTALL CUSTOMER SPACER Ø0.375 O.D. x Ø0.197 I.D. 6061-T6 (QQ-A-200/B, QQ-A-225/B OR QQ-T-700/4) B/N M112567 Acceptable	BE 11/10/25	S 11/10/25	CP 11.09.26 DS/042	S 11/09/26

NOTE: Date & initial all entries

Work Order ID 73681

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Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11-10-6

170



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

11-10-6

11/10/11

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 9/13/2011 Start Qty: 1.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp



180

QC
Quality Control

QC5- Inspect part completeness to step on W/O

0.00 3.0°
4.7°

Memo

0.00

1 0 88/10/11

190



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod
A/R ☐ Aluminum Rod ☒ M117884

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

> DP

11-10-13

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W	11	10	13	①
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210

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8 11/10/13

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

XCM 11/10/13

Dart Aerospace Ltd

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230	White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:00
3200°F
3:30

Handwritten: X of m-l 11/10/13

240	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--



QC

Quality Control

Memo

Handwritten: 1 BL 11-10-17.

250	HandFinishing	0.00							
-----	---------------	------	--	--	--	--	--	--	--



HandFinish

Hand Finishing

Memo

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/R ☐ N/A ☐ LPS-3 ☐ 11/10/13

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R ☐ ☐ Sikaflex-291 ☐ 11/10/13

Sikaflex expire date: ☐ 12-5

Handwritten: 1 BL 11-10-17.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260 QC5- Inspect part completeness to step on W/O 0.00



QC

Quality Control

Memo

Inspect Nut Plate & Inserts

0.00

8/16/17



270 HAND FINISHING RESOURCE #1 0.00



HandFinish

Hand Finishing

Memo

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274
A/R ☐ Sikaflex-291 ☐ 118396 ☐
Sikaflex expire date: ☐ 12-5.

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3
A/R LPS-3 Batch: N/A.

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.
A/R ☐ Sikaflex-291 ☐ 118396 ☐
Sikaflex expire date: ☐ 12-5.

PROCTON. 114.346.

1

BR 11-10-17.

Dart Aerospace Ltd

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280 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5 w/10/17					
290 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo PDD73119	0.00 0.00							
300 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 11/10/19 MF 11-10-18

Dart Aerospace Ltd

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Picklist Print

Tuesday, September 13, 2011 10:19:02 AM

Page 1

Work Order ID: 73681

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube



Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-1-190

Manufactured No

110

Each

78.4000

1

1



Extrusion Round 3" 206

Location

Loc Qty

Loc Code

HALL

78.4

59874

20.4

69622

58

① D P 11-9-14

D3285-1

Manufactured No

110

Each

90.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG002

90

52511

43

52647

47

1

BE 11/09/15

D3282-041

Manufactured No

150

Each

7.0000

1

1



Float Web (206L/407)

Location

Loc Qty

Loc Code

LG

70050

7

72838

7

1

11/09/27

Dart Aerospace Ltd

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Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

D2649

 Cross Bolt Spacer

Manufactured No

190 Each 22.0000 12 12



BE u/10/11
873857 x 12

Location	Loc Qty	Loc Code
LG	10	
68224	2	
71355	2	
72704	6	
LG001	12	
65317	1	
68507	11	

D3275-1

 Crossbolt Spacer

Manufactured No

190 Each 256.0000 12 12



BE u/10/11
873393 x 16

Location	Loc Qty	Loc Code
LG	150	
72123	150	
LG002	106	
66930	106	

CR3212-4-03

 Cherry Rivet

Purchased No

250 Each 1,142.000 2 2



BR 11-10-17

Location	Loc Qty	Loc Code
FP-B	2	
110139	2	
ST311	1140	
114859 ✓	1140	

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3415-041

Manufactured No

250 Each

48.0000 1 1



Nut Plate



BL 11-10-17.

Location

Loc Qty

Loc Code

ST053

48

33842

4

67605 ✓

44

CCR264SS3-3

Purchased No

250 Each

439.0000 2 2



Cherry Rivet



BL 11-10-17.

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

437

117086

27

117849 ✓

410

ALS4-1032-130

Purchased No

250 Each

734.0000 78 78



Insert



BL 11-10-17.

Location

Loc Qty

Loc Code

ST281

370

118386

370

ST282

364

117717

54

118237

98

118312

212

* ALS7-1032-130

118966

78.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 13, 2011 10:19:03 AM

Work Order ID: 73681



Parent Item: D206-642-541




Parent Item Name: Replacement Skidtube

Start Date: 9/13/2011


Required Date: 9/23/2011

Start Qty: 1.00


Required Qty: 1.00

D3536-15 Manufactured No 270 Each 20.0000 1 1
 Gasket
Start Date: 9/13/2011 Required Date: 9/23/2011
Start Qty: 1.00 Required Qty: 1.00
BR 11-10-17.


Location	Loc Qty	Loc Code
FP011	20	
71586 ✓	13	
72881	7	

D3536-23 Manufactured No 270 Each 16.0000 1 1
 Gasket
Start Date: 9/13/2011 Required Date: 9/23/2011
Start Qty: 1.00 Required Qty: 1.00
BR 11-10-17.

Location	Loc Qty	Loc Code
FP011	16	
43406	1	
69902	3	
71579 ✓	12	

D3536-35 Manufactured No 270 Each 21.0000 1 1
 Gasket
Start Date: 9/13/2011 Required Date: 9/23/2011
Start Qty: 1.00 Required Qty: 1.00
BR 11-10-17.

Location	Loc Qty	Loc Code
FP012	21	
71587	12	
72882 ✓	9	

D3536-39 Manufactured No 270 Each 18.0000 1 1
 Gasket
Start Date: 9/13/2011 Required Date: 9/23/2011
Start Qty: 1.00 Required Qty: 1.00
BR 11-10-17.

Location	Loc Qty	Loc Code
FP015	18	
69760 ✓	18	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 13, 2011 10:19:03 AM

Work Order ID: 73681



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-15 Manufactured No

270 Each 19.0000 1 1



Wearshoe

Location Loc Qty Loc Code

FP007 12

73006 ✓ 12

FP018 7

69931 7

D3535-35 Manufactured No

270 Each 10.0000 1 1



Wearshoe

Location Loc Qty Loc Code

FP018 73311 10

65926 1

67598 1

70815 8

D3535-39 Manufactured No

270 Each 17.0000 1 1



Wearshoe

Location Loc Qty Loc Code

FP018 17

69759 4

72159 ✓ 13

D3535-23 Manufactured No

270 Each 16.0000 1 1



Wearshoe

Location Loc Qty Loc Code

FP021 16

70818 6

71581 ✓ 10

BR 11-10-17

BR 11-10-17

BR 11-10-17

BR 11-10-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 13, 2011 10:19:03 AM

Work Order ID: 73681



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No

270 Each 23.0000 1 1



Wearpad



BL 11-10-17

Location Loc Qty Loc Code

FP	4	
70481 ✓	4	
FP017	19	
35697	1	
72144	13	
72686	5	

D3537-1 Manufactured No

270 Each 102.0000 9 9



Wearpad



BL 11-10-17

Location Loc Qty Loc Code

FP001	60	
72124	60	
FP016	35	
68944	0	
70687	35	
FP017	7	
69817	5	
70686	2	

AN960C10L NAS1149C0332 ✓ Purchased No

270 Each 0.0000 80 80



washer

118334



80. BL 11-10-17

AN960C416 NAS1149C0463 ✓ Purchased No

270 Each 0.0000 1 1



washer

117735



1 BL 11-10-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Tuesday, September 13, 2011 10:19:03 AM

Work Order ID: 73681



Parent Item: D206-642-541



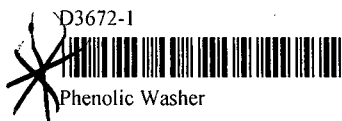
Parent Item Name: Replacement Skidtube

Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00



D3672-1

Manufactured No

270

Each

1,176.000

2

2



BL 11.10.17.

Location

Loc Qty

Loc Code

ST074

1174

64177

178

66821 ✓

496

72229

500

2.

ST077

2

52505

2

AN3C4A

Purchased

No

270

Each

2,992.000

80

80



BL 11.10.17.

BOLT

Location

Loc Qty

Loc Code

ST350

2992

117313

2

117688

5

117795

1

117872

22

118012

20

118112

40

118451 ✓

1000

118628

402

118706

500

118838

1000

80.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 13, 2011 10:19:03 AM

Work Order ID: 73681



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

AN4C5A

Purchased

No

270

Each

485.0000

1

1



BOLT



BL 11-10-17.

Location

Loc Qty

Loc Code

FP-B

96

112243 ✓

96

ST345

389

112243

389

D2646

Manufactured

No

270

Each

91.0000

1

1



Aft Cap



BL 11-10-17.

Location

Loc Qty

Loc Code

FP004

45

68280 ✓

45

FP006

5

62678

5

FP-4

37

70945

1

71070

36

fp5

4

71038

4

D3413-1

Manufactured

No

270

Each

41.0000

1

1



Ring



BL 11-10-17.

Location

Loc Qty

Loc Code

ST420

21

66387

1

70773

20

ST467

20

72137

20

73298.

1.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED

07.02.12

DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

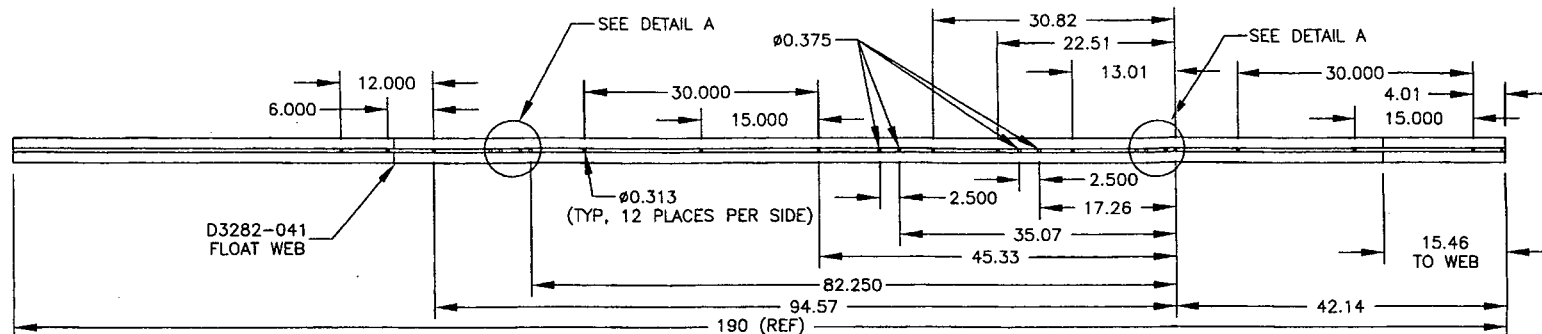
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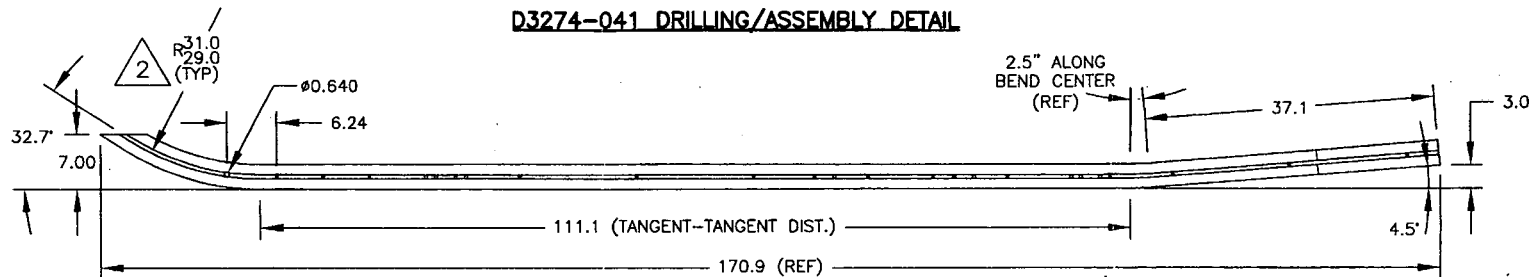
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

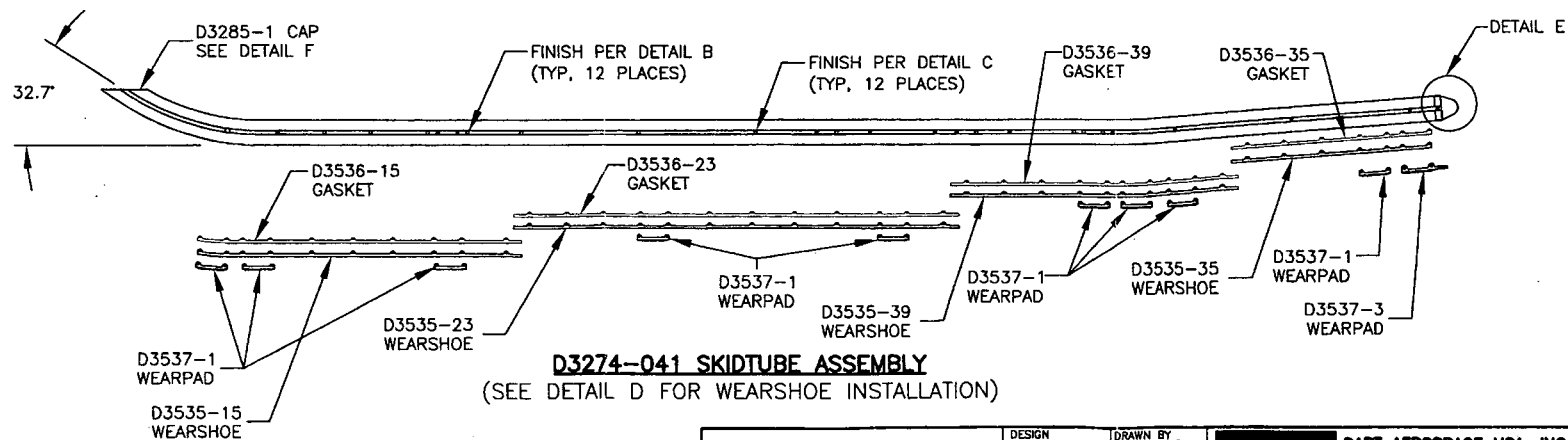
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

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DESIGN

DRAWN BY

DART DART AEROSPACE USA, INC.

CHECKED

APPROVED

DRAWING NO.

REV. D

DATE

D3274

SHEET 2 OF 4

06.12.19

TITLE

SCALE

SKIDTUBE ASSEMBLY

1:15

Dart Aerospace Ltd

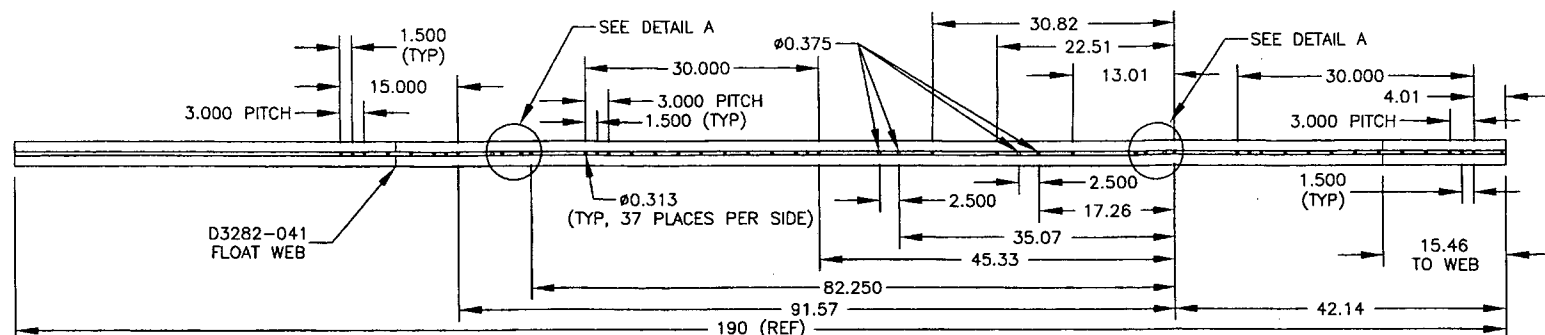
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

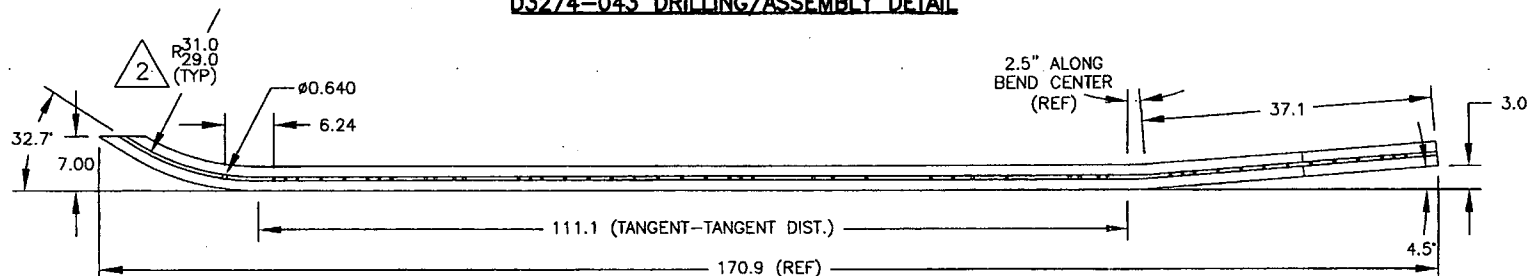
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

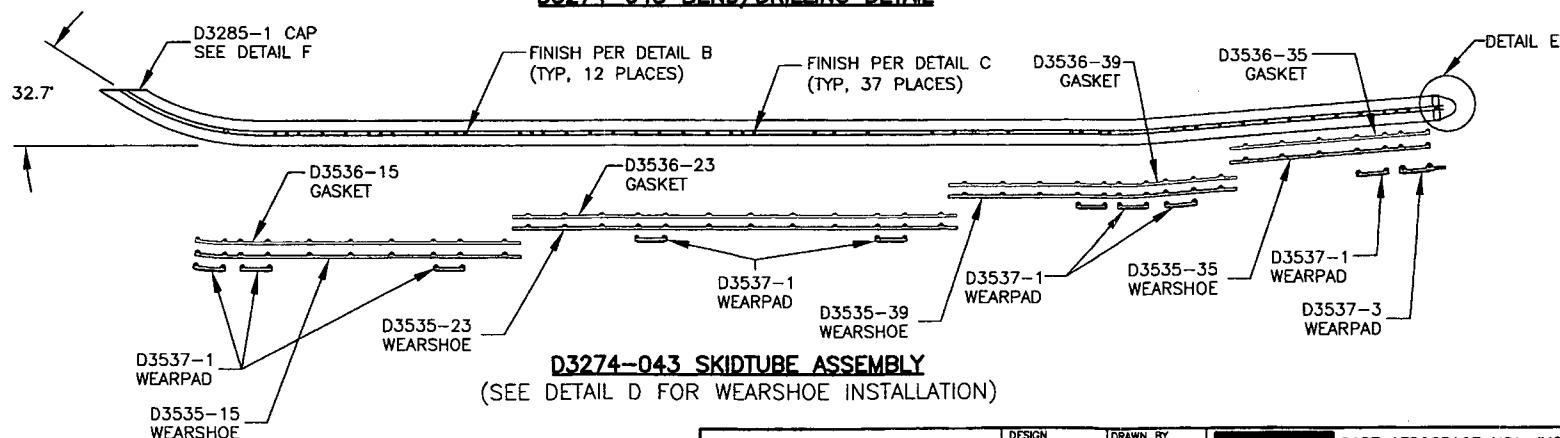
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DESIGN

CP

DRAWN BY

PH

DART DART AEROSPACE USA, INC. PORT HADLOCK, WA

CHECKED

APPROVED

DATE

DRAWING NO.

REV. D

06.12.19

D3274

SKIDTUBE ASSEMBLY

SHEET 3 OF 4

SCALE 1:15

Dart Aerospace Ltd

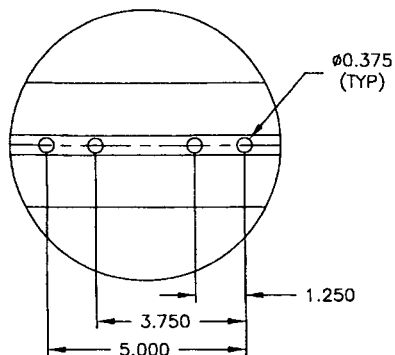
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

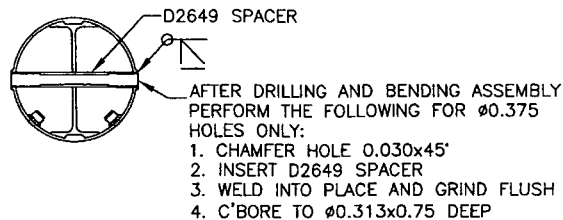
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

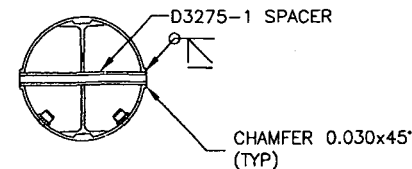
DETAIL A: DRILL DETAIL



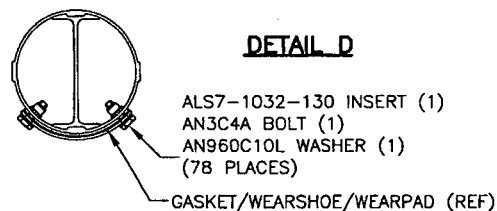
DETAIL B FOR 0.375 HOLES ONLY



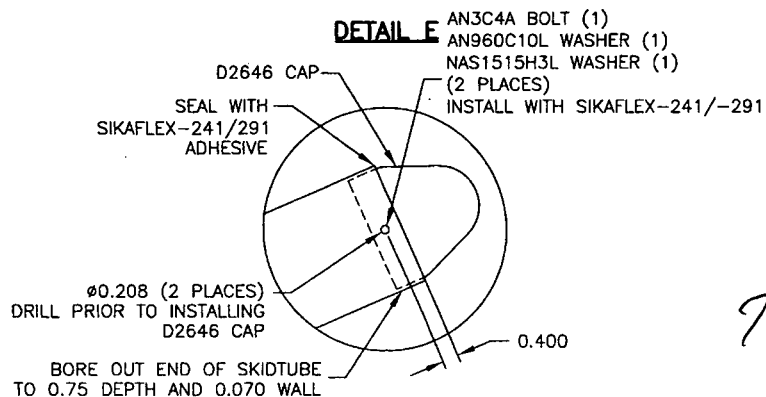
DETAIL C FOR 0.313 HOLES ONLY



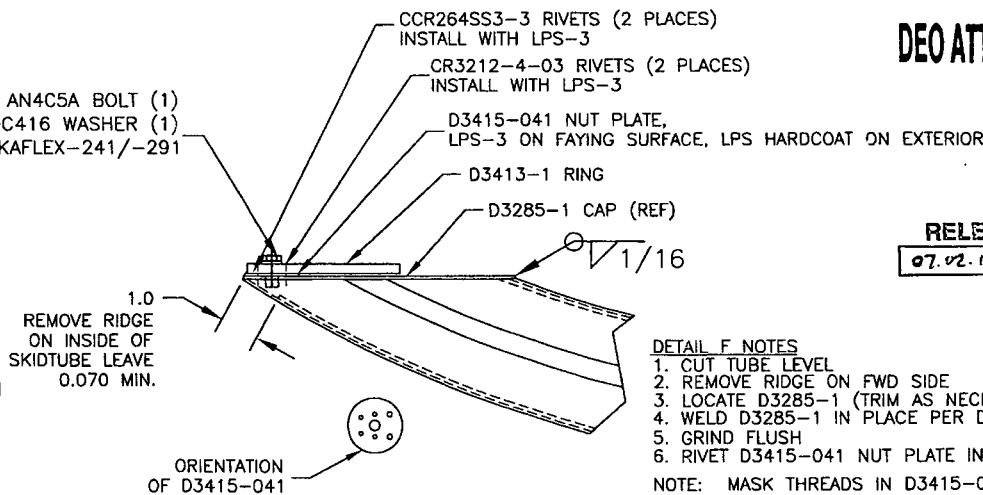
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED
07.02.12

- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

73681

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DATE		06.12.19		TITLE		SKIDTUBE ASSEMBLY	SHEET 4 OF 4
						SCALE	1:3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

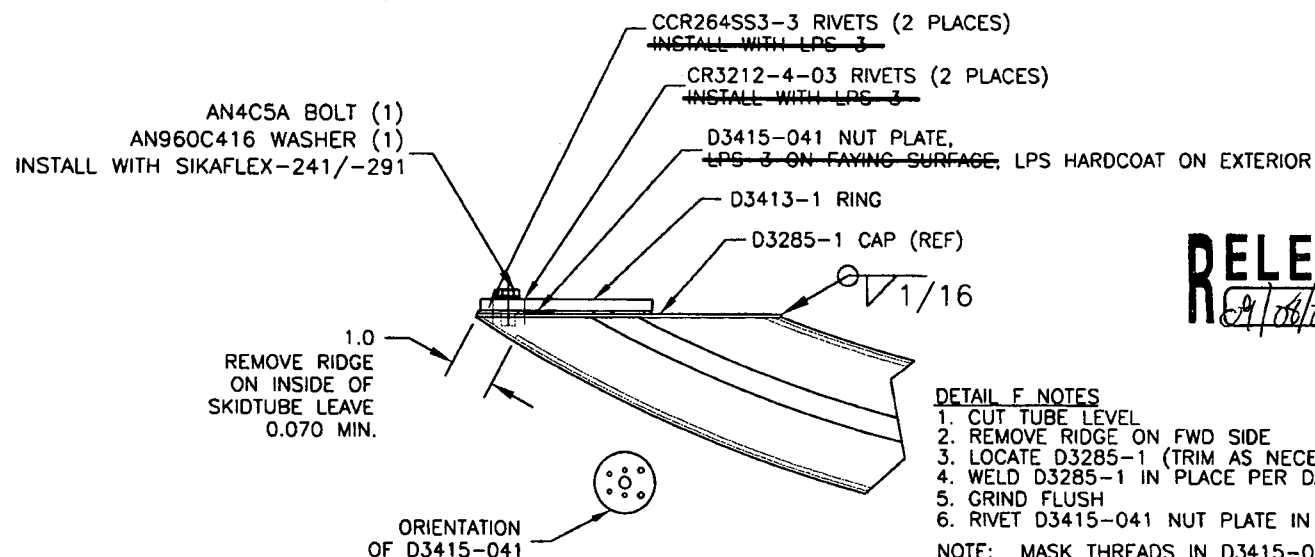
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



RELEASED
09/06/23

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

73481

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 268

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Art Ewers
Job number: B73883
Part number: A206-642-151
Description: Skid tube
Welding Process: Tig[X] Mig[]
Base material: Alum
Current: AC[✓] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[✓] fail[]
Penetration: pass[✓] fail[]

UNACCEPTABLE

Cracks: pass[✓] fail[]
Undercut: pass[✓] fail[]
Pin holes: pass[✓] fail[]
Overlap (cold lap): pass[✓] fail[]
Porosity (surface): pass[✓] fail[]
Coloration: pass[✓] fail[]

Qualifier Samir Amal Date of Test Coupon 6.10.04
Welder Art Ewers Date of Test Coupon 6.10.04

The above named individual is qualified in accordance with AWS D17.1.2001 to weld